

COMPOSITIONS AND METHODS FOR FORMING COATINGS OF
SELECTED COLOR ON A SUBSTRATE AND ARTICLES PRODUCED THEREBY

CROSS REFERENCE TO RELATED APPLICATIONS

5 This application is a divisional application of U.S. Patent Application Serial No. 09/270,702 filed on March 17, 1999, and entitled "Compositions and Methods for Forming Coatings of Selected Color on a Substrate and Articles Produced Thereby", the disclosure of which is hereby 10 incorporated by reference.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The invention relates generally to compositions and methods for forming coatings of selected color on a substrate and more particularly varying the components in aqueous suspensions of organometallic compositions and depositing the suspensions onto a glass substrate to pyrolytically produce a stable coating film of selected color or colors on the glass substrate.

2. Description of the Currently Available Technology

In various industrial applications, it is desirable to form a coating on glass surfaces. For example, automotive windshields have coated areas known as "shade bands" or "fade zones". In many passenger vans, the back seat and rear windows are coated with a uniformly thick coating. These coated areas reduce visible, infrared or ultraviolet light transmittance to reduce glare, the visibility of the contents of the vehicle and/or decrease solar energy transmittance to 30 reduce heat gain in the interior of the vehicle.

One method for forming coatings on a glass substrate is by the pyrolytic deposition of metal oxide films. In U.S. Patent No. 3,660,061 to Donley et al., the disclosure of which is herein incorporated by reference, organometallic salts, such as acetylacetones, are dissolved in an organic solution 35 and are sprayed onto a hot glass surface to form a metal oxide film. In U.S. Patent No. 4,719,127 to Greenberg, the

disclosure of which is incorporated by reference, aqueous suspensions of organometallic salts are sprayed onto a hot glass surface to pyrolytically form metal oxide coatings on the surface.

5 The presently available coating technology is used to form gray or dark gray coatings, particularly in the automotive industry, so that the coated glass can be used with the widest number of automobile body colors without "clashing" with the automobile body color. Additionally, many of the
10 known coated substrates change color or shade upon subsequent heating during tempering and shaping of the coated substrate. This heat induced color shift makes it difficult to produce coated materials of consistent color stability. Further, many of the known coated substrates are not chemically durable e.g.
15 when contacted with solutions having citric acid.

As can be appreciated, it would be advantageous to provide compositions and methods for applying coating(s) of selected transmitted color onto the surface of a substrate which reduce or eliminate the limitations associated with
20 presently known compositions and methods.

SUMMARY OF THE INVENTION

This invention related to a method for forming a coating, e.g., a copper and manganese containing coating, of a
25 desired color on a substrate, e.g., a glass substrate by applying a copper containing component and a manganese containing component onto the substrate in a selected ratio to form the coating having the selected ratio of copper to manganese. More particularly, when the ratio of copper
30 containing component and the manganese containing component is one, the coating is blue in transmission. When the ratio of the copper containing component and the manganese containing component is less than about one, the color varies from gray blue to amber in transmission as the ratio decreases. When
35 the ratio of the copper containing component and the manganese containing component is greater than about one, the color

varies from gray blue to brown in transmission as the ratio increases.

The invention further relates to compositions for forming coatings of a selected color on a substrate. Copper and manganese containing coatings may be used to form coatings ranging from amber to blue to light brown depending upon the copper to manganese ratio. A chromium, copper and manganese system provides a neutral gray colored coating in transmittance. Cobalt may be added to this copper and manganese system to increase chemical durability e.g. the citric acid durability of the coating. An iron oxide system provides a golden colored coating in transmittance. Copper may be added to this iron oxide system to provide a light grayish-brown colored coating in transmittance. Chromium may be added to the copper iron oxide system to provide a darker grayish-brown colored coating in transmission. A manganic oxide (Mn_2O_3) coating provides a mauve/lavender colored coating while a film having an $(Mn^{++}) (Mn^{+++})_2 O_4$ phase provides a light amber colored film. $(Mn^{++}) (Mn^{+++})_2 O_4$ will be referred to as "Mn₃O₄".

The invention still further relates to a method of preventing color shifting of a multi-component or multi-layer coated substrate upon subsequent heat treatment includes the steps of determining the most mobile species in a layer of the coating and placing a concentration gradient layer of an oxide of that mobile species between the substrate, e.g., a glass sheet, and the coating. The concentration gradient layer is preferably applied directly on the glass substrate but may also be applied on a coating layer formed on the glass substrate. Upon subsequent heat treatment, the mobile species in the concentration gradient layer diffuses into the substrate more readily than the mobile species in the coating, which minimizes depletion of the mobile species from the coating and reduces or eliminates an increase in transmittance.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is an isometric view of a coating station embodying features of the invention;

5 Fig. 2 is an isometric view of an alternative embodiment of the coating station of the invention;

Fig. 3 is a bottom view of a CVD coater incorporating the teachings of the invention;

Fig. 4 is a perspective view of an additional coating apparatus embodiment of the invention; and

10 Fig. 5 is a plan view of a coating pattern formed by the apparatus shown in Fig. 4;

Fig. 6 is an end sectional view of a substrate coated by the coating apparatus of Fig. 4.

15 Fig. 7 is a plan view of the Samples A1 through A14 of Table I.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

For purposes of the description hereinafter, the terms "near", "far", "upper", "lower", "right", "left",
20 "vertical", "horizontal", "top", "bottom", "above", "below" and derivatives thereof shall relate to the invention as it is described in the following specification. It is to be understood that the invention may assume various alternative variations and step sequences, except where expressly specified to the contrary. It is also to be understood that the specific methods, compositions, devices and articles described in the following specification are simply exemplary embodiments of the invention. Hence, specific dimensions and other physical characteristics related to the embodiments
25 disclosed herein are not to be considered as limiting to the invention.

In forming a shade band or fade zone on a substrate, it may be desirable to form the fade zone of a selected transmitted color. This may be of particular importance for
30 automotive windows, so that the color of the automobile windows is aesthetically pleasing with respect to the color of

the automobile. In this regard, embodiments of the invention include coating compositions and methods which can be used to form a coating of a selected transmitted color or colors on a glass substrate. These compositions and methods may be used 5 with conventional coating devices, such as but not limited to, conventional chemical vapor deposition (CVD), PVD, MSVD or pyrolytic coating devices. Examples of such conventional coating devices are disclosed in U.S. Patent Nos. 2,676,114; 3,004,875 and 4,138,284, the disclosures of which are herein 10 incorporated by reference.

Alternatively, the compositions and methods of the instant invention may be practiced according to the apparatus and methods disclosed in copending U.S. Patent Application of the same non-provisional filing date entitled "Methods and 15 Apparatus For Forming A Graded Fade Zone On A Substrate And Articles Produced Thereby", the disclosure of which is herein incorporated by reference. The apparatus in this CO-pending application are generally shown in Figs. 1-5 and will be briefly discussed hereinbelow.

With reference to Fig. 1, there is shown a coating apparatus 10 incorporating features of the invention. The coating apparatus 10 includes a coating station 14 for depositing a graded coating on a substrate. In Figs. 1 and 2, the graded coating of the invention is represented by spaced 25 lines of decreasing thickness. However, it is to be understood that this representation is symbolic only, and in actuality the coating of the invention has a non-banded, graded appearance. In the discussion of the invention, although not limiting thereto, a pyrolytic coating is deposited on a heated substrate. Therefore, in the following 30 discussion, a heated chamber, e.g., furnace 12, and a conveyor 16 are utilized with the coating station 14. The conveyor 16 extends from the furnace 12 through the coating station 14 and is configured to transport a substrate 18, e.g., a piece of 35 flat glass to be coated, from the furnace 12 through the coating station 14 at a selected speed. The conveyor 16 can

be of any conventional type, such as a plurality of rotatable metal or ceramic rolls. As can be appreciated, the furnace 12 may be a flat glass forming chamber of the type known in the art where molten glass moves on a metal bath and formed to provide a flat glass ribbon. The conveyor 16 may be the conveyor moving the glass ribbon from the forming chamber to an annealing lehr of the type used in the art to anneal the flat glass ribbon.

The coating station 14 includes a coating dispenser 20, such as a conventional air-atomizing Binks-Sames Model 95 spray nozzle. The coating dispenser 20 is configured to spray an atomized liquid material in a fan or cone-shaped pattern toward a surface of the substrate 18 in the coating station 14. The coating dispenser 20 is in flow communication with a source 22 of coating material, preferably an aqueous suspension of one or more metal acetylacetones or other conventional coating materials, by a flexible conduit 24. Suitable coating materials are disclosed, for example, in U.S. Patent No. 4,719,127 to Greenberg, which disclosure is herein incorporated by reference. A metering pump 26, such as a conventional Cole-Parmer MasterFlex 07523-20 pump, is in flow communication with the conduit 24. The coating dispenser 20 is also in flow communication with a source 28 of compressed fluid, such as air, by a flexible conduit 30.

The coating dispenser 20 is preferably mounted for pivotal, lateral and vertical movement in any usual manner on a support 34, such as a metal frame. Preferably the coating dispenser 20 is mounted relative to the glass piece to be coated or the supporting surface of the conveyor 16 such that an angle α (shown only in Fig. 1) of between about 0-90°, preferably between about 20-40°, is formed between an imaginary axis or line L drawn through the center of the spray emitting from the nozzle or discharge end of the coating dispenser 20 and a vertical axis V extending substantially perpendicular to the supporting surface or the surface of the substrate 18 being coated. The coating dispenser 20 is also

vertically and horizontally movable such that the height of the coating dispenser 20 above the conveyor 16 as well as the position of the dispenser 20 along the conveyor 16 and the lateral position of the coating dispenser 20 with respect to the conveyor 16 can be selectively fixed. While only one coating dispenser 20 is shown in Fig. 1, a plurality of such coating dispensers 20 can be located on the first support 34, for example, beside, over or under the first coating dispenser 20.

A first exhaust hood 40 is located upstream of the coating dispenser 20 with respect to direction of travel of the conveyor 16 as indicated by arrowed line designated by the numeral 41, and a second exhaust hood 42 is located downstream of the coating dispenser 20 with respect to direction of travel of the conveyor 16. Optionally and preferably, a temperature sensor 43, such as a conventional infrared thermometer, may be positioned above the conveyor 16 adjacent to the first exhaust hood 40 to sense the temperature of the substrate 18 for pyrolytic coating. Each exhaust hood 40 and 42 is in flow communication with a respective exhaust conduit 44 or 45. An auxiliary exhaust hood 49 may be located near the far side of the substrate 18 away from the coating dispenser 20 to provide additional exhaust capability. To avoid an unwanted overspray onto the glass surface, a barrier 51 shown in Fig. 2 may be provided and/or the hood 49 may be used. In this manner, the spray from the coating dispenser 20 is not contacted preventing interference with the spray while any randomly airborne coating material will be prevented from being carried and deposited on the portion of the glass forthwith from the coating dispenser 20.

With continued reference to Fig. 2 there is shown a coating apparatus 100 incorporating features of the invention. The coating apparatus 100 includes a second coating station 114 having a second coating dispenser 120 pivotally mounted on a second support 134. A third exhaust hood 47 is located downstream of the second exhaust hood 42. Although not shown

in Fig. 2, auxiliary exhaust hood 49 as shown in Fig. 1 may also be located in the first and second coating stations 14 and 114 respectively. The second support 134 is laterally spaced from the first support 34 so that the second coating dispenser 120 is located between the second and third exhaust hoods 42 and 47. As shown in dashed lines in Fig. 2, additional coating dispensers 121 may be located at the second coating station 114, for example, beside, over or under the second coating dispenser 120. In both the apparatus 10 and 100, no shield or deflector is located between the spray from the coating dispensers and the object being coated.

The second coating dispenser 120 may be in flow communication with the source 28 of compressed fluid and the source 22 of coating material of the first coating dispenser 20 to spray the same coating material onto the substrate 18. Alternatively, as shown in Fig. 2, the second coating dispenser 120 may be in flow communication with a separate source 128 of compressed fluid by a conduit 130 and a separate source 122 of coating material by a conduit 124 having a metering pump 126 to spray the same or a different coating onto the substrate 18. The additional coating dispenser 121 may similarly be in flow communication with the same or different sources of compressed fluid and coating material as the coating dispensers 20 and 120.

Operation of the coating station 14 will now be described with particular reference to the embodiment shown in Fig. 1. In the following discussion, the heating chamber or furnace 12 of Fig. 1 may be considered the chamber 50 of Fig. 3 for a continuous piece of glass, e.g., a glass ribbon, or as a conventional furnace for individual glass pieces.

A continuous substrate, e.g., a glass ribbon, or discrete substrates 18 to be coated, such as pieces of flat glass, are heated to a desired temperature in the chamber 50 or the furnace 12, respectively. The conveyor 16 transports the heated substrates 18 into the coating station 14. The coating dispenser 20 is selectively positioned at a desired

height and lateral position, i.e., distance from the side of the conveyor 16, and at an angle α such that when the substrate 18 is transported through the coating station 14, the coating dispenser 20 directs the coating material onto the upper surface of the substrate 18. This positioning of the coating dispenser 20 can be done either manually or automatically by a conventional automated positioning device attached to the coating dispenser 20.

As the substrate 18 moves through the coating station 14, coating material is moved from the coating material source 22 to the coating dispenser 20 and mixed with compressed air from the compressed fluid source 28 to exit the nozzle of the coating dispenser 20 as a cone-shaped spray pattern of coating material directed toward the hot substrate 18. The first and second exhaust hoods 40 and 42 exhaust excess coating material from the coating station 14 to provide an essentially defect or blemish free uniform coating. The auxiliary exhaust hood 49 may also be used to further enhance the exhaust from the coating station 14. As discussed above, to prevent coating particles in the air from moving over and depositing on the portion of the ribbon furthest from the coating dispenser, a barrier 51 shown in Fig. 2 may be used. As the substrate 18 moves through the coating station 14, the coating dispenser 20 sprays the coating material onto the top of the hot substrate 18, where the coating material pyrolyzes to form a substantially durable graded pyrolytic coating.

The size of the spray fan as measured at the glass surface, the speed of the conveyor 16 and the distance between the nozzle of the coating dispenser 20 and the substrate 18 are fixed such that the spray pattern forms a desired coating distribution or grade on top of the substrate 18. Coating pressures and volumes through the coating dispenser 20 are selectively controlled to deposit a desired coating gradient and thickness on the surface of the substrate 18. Because the coating dispenser 20 is angled toward the far side of the substrate 18; a thicker layer of the coating material is

deposited on the near side of the substrate 18, i.e., the side of the substrate closest to the coating dispenser 20, and the thickness of the coating material deposited on the substrate 18 decreases as the distance from the opposite edge of the 5 substrate (the edge furthermost from the coating dispenser) decreases, with a substantially continuous thickness gradient occurring therebetween; i.e., as the distance from the coating dispenser 20 increases, the coating thickness decreases.

Thus, a smooth, substantially continuously graded coating 10 material 60 is applied across a desired width of the upper surface of the substrate 18. Since no shields or deflectors common in the prior art are required to practice the invention, the resulting coating forms a smooth, continuous gradient on the substrate 62 without the banding or mottling 15 limitations common with prior art coating devices. Also, by using a pyrolytic coating material rather than the dyes common in the prior art, the resulting coated substrate of the invention can be directly utilized, e.g., as an automotive transparency, without the need for additional protective 20 measures such as protective overcoats or lamination generally required for the dye coated substrates of the prior art.

As will be understood by one of ordinary skill in the art of coating glass, the coating system parameters may affect the resulting coating. For example, all else remaining 25 equal, the faster the substrate 18 is moved through the coating station, the thinner will be the overall thickness of the coating. The larger the angle, the thinner will be the coating near the coating dispenser 20 and the thicker will be the coating farther away from the coating dispenser 20. As 30 the distance of the coating dispenser 20 above the substrate 18 increases, the thinner will be the overall coating. The larger the flow rate of coating material through the coating dispenser 20, the thicker will be the overall coating.

Example #1

Pieces or substrates of flat glass (commercially available from PPG Industries, Inc. of Pittsburgh, Pennsylvania, under the registered trademark SOLARBRONZE®) approximately 0.157 inch (4.0 mm) thick, 24 inches (60.1 cm) wide and 30 inches (76.2 cm) long were coated with the coating station of the invention shown in Fig. 1. The substrates were washed with a dilute detergent solution, rinsed with distilled water and then air dried. The cleaned glass substrates were heated in an electric horizontal roller hearth furnace with a furnace temperature of about 1150°F (621°C). The heated substrates were transported by the conveyor from the furnace through the coating station at a line speed of about 250 inches (635 cm) per minute. The temperature of the substrates entering the coating station was about 1135-1139°F (613-615°C), as measured by the infrared thermometer 43 positioned above the conveyor just upstream of the first exhaust hood 40. The coating material used was an aqueous suspension of a mixture of finely ground metal acetylacetones mixed in water at 16.5 wt% and having a specific gravity of 1.025 measured at 72°F (22°C). The metal acetylacetone mixture consisted of 95 wt% Co (C₅H₇O₂)₃, hereinafter referred to as "cobaltic acetylacetone" and 5 wt% Fe(C₅H₇O₂)₃, hereinafter referred to as "ferric acetylacetone". The aqueous suspension was placed in a container having an impeller type mixer operated at 352 rpm to maintain the suspension. The liquid suspension was delivered to the spray nozzle by a laboratory peristaltic metering pump (Cole-Parmer MasterFlex 07523-20) at a rate of 85 milliliters per minute. The spray nozzle was a conventional air-atomizing type (Binks-Sames model 95) and compressed air was utilized at a pressure of 50 lbs. per square inch, gauge (3.5 kg/sq. cm). The spray nozzle was laterally positioned about 7 inches (17.8 cm) from the near side of the substrate and was vertically positioned about 11 inches (27.9 cm) above the surface of the glass substrate to be coated. The spray nozzle was angled such that a centerline

of the nozzle intersected the top of the substrate at an angle α of about 25° . This arrangement produced a graduated, substantially bronze colored fade zone on the glass substrate.

As shown in Fig. 2, a number of coating stations 14, 5 114 may be located in series to apply the same or a different coating material onto the substrate 18 at each coating station 14, 114. For example, it may be desirable to create a layered or stacked coating or to create a selected color on the substrate or to form multiple colors on the same substrate.

10 Although the above discussion focused on the practice of the invention with a coating device utilizing conventional air atomizing spray nozzles, the invention is not limited to such coating devices but may be practiced with other types of coating devices and processes, e.g., coaters 15 for vapor depositing a coating ("CVD coaters"), combustion CVD coaters, sputter coatings using cathodes of single or multiple components e.g. copper and manganese or sol-gel coatings.

As will be appreciated by one of ordinary skill in the CVD coating art, CVD coaters are usually located above a 20 moving substrate. The coating block includes delivery slots through which coating material is discharged and one or more exhaust slots positioned transversely to a direction of movement of the substrate. A bottom 138 of a CVD type coating block 140 incorporating the principles of the present 25 invention is shown in Fig. 3. The CVD coating block 140 has at least one tapered coating delivery slot 142, tapering from a narrower width at one end to a wider width at the other end, through which a coating material may be directed in conventional manner toward the surface of a substrate moving 30 in the direction of arrow X under the coating block 140. Exhaust slots 144 are located on each side of the delivery slot 142. The exhaust slots 144 may be of uniform width as shown in Fig. 3 or may be tapered, e.g., in similar manner to the delivery slot 142. Alternatively, the delivery slot 142 35 may be of uniform width and the exhaust slots 144 tapered. A thicker coating will be applied to the substrate surface under

the narrower portion of the delivery slot 142 than under the wider portion of the delivery slot 142, with a graded coating thickness being deposited therebetween.

Fig. 4 shows a further embodiment of a coating station 148 of the invention. The coating station 148 has a first exhaust hood 40 spaced from a second exhaust hood 42 with a plurality of staggered, spaced apart coating dispensers 200, e.g., conventional air atomizing spray nozzles, located therebetween. In the embodiment shown in Fig. 4 but not to be considered as limiting to the invention, three such coating dispensers 200 are shown. The coating dispensers 200 are preferably movably or pivotally mounted on a stationary frame above a conveyor 16 used to transport a substrate 18 to be coated into the coating station 148. Of course, the coating dispensers 200 could alternatively be mounted on a movable frame or gantry to move the coating dispensers 200 relative to the substrate 18. The coating dispensers 200 are in flow communication with one or more sources of coating material and/or pressurized fluid.

As shown in Fig. 4, the coating dispensers 200 are preferably directed downwardly toward the substrate 18 to form spray patterns, such as elliptical or elongated spray patterns 150, on the substrate 18. As shown in Fig. 5, each elongated pattern 150 has a major axis 152 with a center 154 and an outer periphery or edge 156. The coating dispensers 200 are arranged so that the spray pattern from one coating dispenser 200 does not interfere with the spray pattern from another coating dispenser 200. For example, the coating dispensers 200 may be arranged in a staggered formation such that the major axes 152 are all substantially parallel and are spaced apart. As shown in Fig. 5, each coating dispenser 200 forms a coated area 158 on the substrate 18 as the substrate 18 moves through the coating station 148. The coating dispensers 200 are preferably positioned such that the coated area 158 formed by one coating dispenser 200 does not extend beyond the pattern center 154 of an adjacent coating dispenser 200. Thus, the

coated areas 158 overlap to form a coating as shown in Fig. 6 as having a substantially uniformly thick center region 162 with tapered or graded side regions 164 located at each side of the coating. If desired, the coated substrate 18 may be 5 cut into two or more pieces. For example, the substrate 18 may be cut in half along a central vertical axis to form two separate coated pieces, with each piece having a graded side region 164 or the piece 18 may be cut into three pieces with the center piece having a uniform coating and the outer pieces 10 having the graded region.

While in the embodiment discussed above coating dispensers 200 forming elliptical coating patterns were discussed, the invention is not limited to such elliptically shaped coating patterns. The coating patterns may, for 15 example, be of any shape, e.g., circular, oval, etc. Additionally, a plurality of such coating stations 148 may be positioned in series to spray the same or different coating materials onto the substrate.

Specific coating compositions and methods to achieve 20 coatings of selected transmitted color will now be described. These compositions and methods are generally grouped in accordance with the color produced for ease of discussion. However, the particular groupings should not be considered as limiting to the invention.

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COPPER-MANGANESE OXIDE COATINGS

Coatings, particularly pyrolytically deposited 30 coatings, formed using a suspension having copper containing and manganese containing components are found to provide excellent coatings ranging in transmitted color from amber or light brown to blue-gray to blue, depending upon the molar ratio of copper to manganese in the applied suspensions. Specifically, aqueous suspensions containing a mixture of manganese containing acetylacetones (e.g., $Mn(C_5H_7O_2)_2$, 35 hereinafter referred to as "manganous acetylacetones" or $Mn(C_5H_7O_2)_3$, also referred to as "manganic acetylacetone") and

copper containing acetylacetones (e.g. $Cu(C_5H_7O_2)_2$, also referred to as "cupric acetylacetone") have been found to produce coatings ranging in transmitted color from a light brown with high copper content or an amber color with high manganese content to a blue color as the copper to manganese molar ratio in the coating is one and to a blue-gray color as the molar ratio is slightly greater or less than 1. Changes in colors as the copper to manganese molar ratio increases or decreases are listed in Table I and shown in Fig. 7 which are discussed below in more detail.

Coated substrates were formed by hand spraying aqueous suspensions of mixed copper and manganese containing acetylacetones, such as cupric and manganous acetylacetones, onto clear float glass substrates cut into 4 inch x 4 inch (10.2 cm x 10.2 cm) squares. The substrates were washed with a dilute detergent solution, rinsed with distilled water and then air dried. An aqueous suspension of cupric acetylacetone $Cu(C_5H_7O_2)_2$ and manganous acetylacetone $Mn(C_5H_7O_2)_2$ was produced by a conventional wet grinding technique and the copper and manganese containing acetylacetones were mixed in the desired proportions with deionized water and a chemical wetting agent to disperse, deaerate and suspend the metal acetylacetone particles. The substrates were heated in a conventional bench top muffle furnace to a temperature sufficient to ensure pyrolysis of the applied suspensions, e.g., about 600°C and then hand sprayed with a Binks model 95 spray gun equipped with a gravity feed reservoir.

The range of transmitted and reflected color of the coated substrates, as a function of composition, are shown in Table I and the color of the samples shown in Fig. 7. The reflected and transmitted colors of the coated substrate are set forth in conventional manner using the standard chromaticity coordinates Y, x, y , for illuminant A, 2° observer established by the Commission Internationale de l'Eclairage (CIE). The coated substrates were analyzed using X-ray

diffraction. Samples A6 to A8 of Table I were found to contain as a majority phase a cubic $Cu_{1.4}Mn_{1.6}O_4$ spineltype phase occurring generally in the range of 0.8 to 1.1 Cu/Mn molar ratio in the coating as determined by X-ray Fluorescence ("XRF"), see Table I. The Cu rich coatings of Samples A1 and A2 were brown colored in transmission, and the Mn rich colored coatings were amber colored in transmission as in Samples A13 and A14.

Table I

Reflectance and Transmittance CIE Chromaticity Coordinates for CuMn Oxide Films on Clear Glass

Sample	Suspension	Cu(II)/Mn(II) Molar Ratio in Film	Cu/Mn Molar Ratio in Film (XRF)	* (ill. A, 2°)			** (ill. A, 2°)			*** (ill. A, 2°)		
				Y	X	Y	X	Y	X	Y	X	Y
A1	Cu Only	Cu Only	23.81	0.4350	0.4084	17.41	0.4419	0.4131	57.13	0.4679	0.4139	
A2	9.00	20.57	26.27	0.4389	0.4092	19.61	0.4400	0.4122	52.71	0.4676	0.4135	
A3	4.00	5.48	19.06	0.4338	0.4047	11.38	0.4347	0.4072	58.87	0.4576	0.4131	
A4	2.03	2.42	26.92	0.4517	0.4047	12.04	0.4312	0.3945	37.26	0.4399	0.4115	
A5	1.50	1.75	24.87	0.4610	0.4044	10.83	0.4460	0.3937	35.78	0.4290	0.4090	
A6	1.00	1.10	28.22	0.4778	0.4075	13.61	0.4769	0.4009	27.46	0.4065	0.4029	
A7	0.82	0.91	24.56	0.4734	0.4057	9.82	0.4722	0.3960	34.78	0.4149	0.4058	
A8	0.67	0.79	28.52	0.4734	0.4067	13.09	0.4698	0.3978	27.85	0.4107	0.4039	
A9	0.54	0.86	23.97	0.4597	0.4027	9.71	0.4432	0.3887	38.16	0.4266	0.4083	
A10	0.49	0.61	27.00	0.4641	0.4036	12.74	0.4500	0.3932	31.37	0.4213	0.4075	
A11	0.33	0.38	27.07	0.4452	0.4021	13.88	0.4203	0.3915	40.13	0.4389	0.4109	
A12	0.25	0.28	24.90	0.4355	0.4009	15.14	0.4146	0.3950	49.09	0.4478	0.4125	
A13	0.11	0.12	25.23	0.4235	0.4019	20.52	0.4177	0.4045	61.80	0.4600	0.4147	
A14	Mn Only	Mn Only	31.17	0.4294	0.4076	28.89	0.4266	0.4114	61.68	0.4650	0.4150	

*Film side reflected chromaticity values of as deposited film.

**Reflected chromaticity value of side opposite as deposited film side.

***Transmitted chromaticity value of as deposited film on glass.

Example #2

In this example, substrates were prepared and coated as follows. Four millimeter thick float glass substrates, 4 inch x 4 inch (10.2 cm x 10.2 cm) squares, were cleaned by passing the substrates through a dilute detergent solution, rinsing the substrates with distilled water and then air drying the substrates. The cleaned glass substrates were sprayed with a 50/50 volume percent solution of two-propanol and distilled water, and wiped dry with a cellulose-polyester cloth to remove dirt, unwanted film, fingerprints and/or debris. Aqueous suspensions of cupric acetylacetone and manganic acetylacetone were provided by conventional wet grinding techniques. These single metal acetylacetone suspensions were mixed together to create binary suspensions with Cu/Mn molar ratios in the range of 9.09 to 0.43. The glass substrates were transferred into a bench top muffle furnace and heated to a temperature of about 600°C. The heated substrates were hand sprayed with a spray gun equipped with a gravity feed reservoir to apply the aqueous suspension onto the substrate. The spray gun used in the experiment included a Binks model 63 PB aircap, a Binks model 63 SS fluid nozzle and a Binks model 663 needle. The atomizing air pressure of the gun was set at 50 PSI. The aqueous suspension was sprayed onto the substrate for about 8 seconds at a distance of about 10 inches (25.4 centimeters) from the glass surface.

As shown in Table II, films having a higher Cu/Mn mole ratio equal to or greater than about 15.13 produced coated substrates having a brown color in transmittance. As the Cu/Mn mole ratio as determined by XRF in the film decreased, the transmitted color changed from light brown to grayish blue to deep blue to a lighter blue for Sample Nos. B1-B9 of Table II. The deep blue-colored coatings of Sample Nos. B6-B8 of Table II in transmission were determined by XRF analysis to contain a majority of a cubic $Cu_{1.4}Mn_{1.6}O_4$ spinel-

type phase and generally occurred in the range of 0.8 to 1.2 Cu/Mn molar ratio in the film, as determined by XRF. After deposition, the coated substrates were heated to 650°C for about ten minutes. This heating caused a change in percent luminous transmittance (ΔY) and in color which is shown in Table II as ΔE (FMCII). For ease of discussion, an increase in transmittance which occurs after heat treatment will be referred to herein as "bleaching". ΔE (FMCII) in Table II is defined as the difference in color of the coated substrate before and after heating. ΔE (FMCII) is determined in accordance with the conventional formula established by the Colorimetry Committee of the CIE.

It should be noted that the blue-colored spinel-type phase of $Cu_{1.4}Mn_{1.6}O_4$ can be produced by using a Cu(II)/Mn(II) acetylacetone suspension as in Sample Nos. A6-A8 in Table I. The same spinel-type phase is observed for the Cu(II)/Mn(III) acetylacetone suspension used for samples B6-B8 in Table II. Although Table I does not show the results after heat treatment of Sample Nos. A6-A8, it is expected that these 20 samples bleach in a similar manner as Sample Nos. B6-B8 in Table II.

Table II

Sample No.	Cu(II) / Mn(III) Suspension Mole Ratio	Cu/Mn Mole Ratio in Deposited Films (XRF)	Transmitted chromaticity value for as deposited film III. A., 2°	Change in transmitted chromaticity value after heat treatment at 650°C, 10 mins. III. A., 2°			ΔE (FMClI)
				Y	X	Y	ΔY
B1	9.09	15.13	50.59	0.4713	0.4135	2.56	-0.0049
B2	4.00	5.93	47.98	0.4644	0.4138	2.95	-0.0111
B3	2.33	3.31	38.66	0.4538	0.4135	1.90	-0.0130
B4	1.49	2.11	38.56	0.4417	0.4188	2.14	-0.0123
B5	1.00	1.41	37.15	0.4288	0.4089	6.42	-0.0058
B6	0.82	1.15	31.57	0.4164	0.4058	7.07	0.0041
B7	0.67	0.94	29.57	0.4112	0.4043	7.10	0.0103
B8	0.54	0.78	23.55	0.4044	0.4009	8.13	0.0167
B9	0.43	0.60	39.38	0.4266	0.4082	6.88	0.0100

Diffusion Couple Experiments

In a Cu-Mn system, copper is the more mobile species. This determination was formed based on the following experiments. A CuO film was sprayed onto the surface of a first heated quartz substrate. In the following discussion, the substrates were about 600°C when coated. A Mn₃O₄ film was sprayed onto the surface of a second heated quartz substrate. The two substrates were then coupled face to face with portions of the coated surfaces in contact with one another and the remaining portion of the coated surface spaced from one another, i.e., the portions of the coated surface were out of contact with one another. The substrates were heated to 650°C for 16.2 hours. Upon separation, a portion of the coated surface of the second substrate in direct contact with the CuO film of the coated surface of the first substrate showed a dark blue color as viewed with the unaided eye. This is believed to be due to Cu ions migrating from the CuO film into the Mn₃O₄ film to form a dark blue colored coating of Cu_{1.4}Mn_{1.6}O₄ spinel-type phase. The corresponding area of the CuO film was much lighter upon heating, indicating a depletion of Cu ions. The portion of the Mn₃O₄ film on the second substrate not in contact with the CuO film converted upon heating from amber to a mauve/lavender colored Mn₂O₃ film.

In a further experiment, a CuO film was deposited on a heated quartz substrate and an Mn₃O₄ film was deposited on a heated glass substrate. The two substrates were then coupled face-to-face with portions of the coated surfaces in contact with one another and the remaining portions out of contact with one another. The substrates were heated to 650°C for 30 minutes. Upon separation, portion of the coated surface of the second substrate in direct contact with the CuO film of the coated surface of the first substrate showed a dark blue color in transmission as viewed with the unaided eye. This is believed to be due to the migration of copper ions from the copper oxide (CuO) film to the Mn₃O₄ film to form the dark blue colored Cu_{1.4}Mn_{1.6}O₄ spinel-type phase. The corresponding film

area on the quartz substrate was very light, indicating a depletion of Cu ions. The remaining areas of the films were little changed, indicating that the Cu ions do not easily diffuse into quartz but preferentially diffuse into the Mn₃O₄ film deposited on the glass substrate to form the dark blue-colored Cu_{1.4}Mn_{1.6}O₄ spinel-type phase. This also indicates that Mn ions do not preferentially diffuse into glass or that they diffuse much more slowly than Cu ions.

A CuO film was deposited on a heated glass substrate and a Mn₃O₄ film was deposited on a heated quartz substrate. The two substrates were then coupled face to face and heated to 650°C for 30 minutes. Upon separation, the surfaces of the amber colored Mn₃O₄ film on quartz out of contact with the copper oxide film on the glass converted to a lavender colored Mn₂O₃ film. A small portion of the quartz substrate showed a blue colored area, indicating the presence of the dark blue colored Cu_{1.4}Mn_{1.6}O₄ spinel-type phase. However, most of the Cu diffused into the glass rather than towards the Mn₃O₄ film deposited on quartz. Thus, from these experiments, it was concluded that Cu ions are the more mobile species in the CuMnO_x system and is the main species that must be prevented from diffusing into the glass substrate.

PREVENTION OF BLEACHING

As discussed with respect to Example #2 above, as-deposited thin films on glass substrates tend to change color after subsequent heat treatment, such as tempering or annealing. This is believed to be due to the ion exchange of mobile species between the coating layer and the glass substrate. It is known to place inert layer(s) between the glass substrate and the coating to act as a barrier layer to help prevent such diffusion. However, these barrier layers are not always effective. Therefore, an alternative method of stopping or slowing down such diffusion by the use of a concentration gradient layer located between the coating layer

and the substrate has been developed. This concept may be generally explained as follows:

If a single layer oxide coating, represented for example as ABCO_x for purposes of discussion where A, B and C are metal ions in the coating layer, is known to change color, i.e., bleach after heat treatment, due to B ions, for example, diffusing into the glass substrate in exchange for D ions, for example alkali ions, coming out of the glass substrate, a thin film of BO_x may be deposited between the glass substrate and the ABCO_x coating. As can be appreciated, the invention may be practiced with a single layer oxide coating having two or more metal ions. The BO_x layer provides a sacrificial or concentration gradient layer to prevent such bleaching. B ions from this sacrificial layer diffuse into the glass more readily than the B ions from the ABCO_x coating layer. Thus, by placing a BO_x layer between the ABCO_x layer and the glass, the B ions in the BO_x undercoat layer partially or fully diffuse into the glass. The BO_x layer acts as a concentration gradient deterrent layer to prevent or slow down B ions from the top coating layer or the ABCO_x coating layer from diffusing into the glass substrate. Consequently, B ions in the top coat ABCO_x layer diffuse more slowly into the undercoat BO_x layer, if at all, and thus minimize the degradation of the ABCO_x layer while B ions from the BO_x undercoat layer diffuse mostly into the glass and perhaps slightly into the top coat layer. The transmitted color of the coated glass can thus be controlled by the thickness and composition of the BO_x layer, as well as the thickness and composition of the top coat layer ABCO_x . This results from the fact that as a function of time, temperature and film thickness, most or all of the BO_x layer can be broken down such that substantially only the desired ABCO_x top coat layer is left behind. The BO_x layer is preferably deposited directly on the glass substrate but may also be deposited on another coating layer deposited on the substrate.

For purposes of acting as a concentration gradient deterrent layer, the BO_x layer should be deposited to both minimize a color change in the coated glass and also to minimize the diffusion of B ions away from the top coat layer 5 into the glass. For example, the above-described $\text{Cu}_{1.4}\text{Mn}_{1.6}\text{O}_4$ blue colored films may bleach upon heat treatment resulting in breakdown of the crystal structure of the chromophore to the point where the color may no longer be present (for example, heating at 650°C for 16 hours) and the Cu and Mn ions have 10 diffused into the glass. As was discussed above, copper is the most mobile species in this system. Therefore, a two layer system was made comprising glass/ $\text{CuO}/\text{Cu}_{1.4}\text{Mn}_{1.6}\text{O}_4$.

Experimental results for the deposition of a CuO layer of varying thickness are shown in Table III below. The 15 coatings were deposited on heated pieces of float glass on the side of the glass unsupported on the tin bath during manufacture. The unsupported surface was coated to emulate what is currently done on line for pyrolytically or CVD coating on a float ribbon. The tin rich surface of the 20 piece of glass cut from the float ribbon can be coated during laboratory experiments. However, it has been determined that the tin rich surface of the glass acts as a barrier to diffusion of ions from a coating into the glass during heat treatment and that the tin ions act as a barrier. The CuO 25 layer was deposited on the glass followed by depositing the $\text{Cu}_{1.4}\text{Mn}_{1.6}\text{O}_4$ layer on the CuO layer. The thickness of the CuO layer was varied by varying the spray time for applying the copper acetylacetone suspension onto the glass substrate, i.e., a two second spray time yields a thinner resultant CuO 30 layer than an eight second spray time. The thicknesses of the CuO layers range from about 50\AA for a two second spray time to about 200\AA for an eight second spray time. As can be appreciated the invention is not limited to the thickness of the copper oxide layer and thicknesses in the range of 35 $25 \text{ Angstroms} (\text{\AA})$ - 260 \AA are acceptable in the practice of the invention. The thickness of the $\text{Cu}_{1.4}\text{Mn}_{1.6}\text{O}_4$ layers was not

varied and had a thickness of about 300Å . The $Cu_{1.4}Mn_{1.6}O_{1.4}$ film was deposited by spraying copper (II) and manganese (III) acetylacetones in the molar ratio of 0.54 for 8 seconds to deposit a layer having a thickness of about 300 Å . As can be appreciated, the invention is not limited to the thicknesses of the $Cu_{1.4}Mn_{1.6}O_{1.4}$ films and thicknesses in the range of 100Å-700Å are acceptable. The thicknesses of the films of the Samples were determined by spectroscopic ellipsometry.

The bleaching effect is clearly noted for coatings deposited on glass, e.g. glass made by the float process; however, for coatings deposited on quartz, the bleaching effect is not as pronounced as for glass substrates because there is little to no ion exchange between the quartz substrate and coating because the quartz substrate has ions present in the parts per million thereby reducing ion exchange.

Table III

The effect of varying the CuO layer thickness of Clear Glass/CuO/Cu_{1.4}Mn_{1.6}O₄ samples before and after heat treatment at 650°C for 10 minutes. The Cu_{1.4}Mn_{1.6}O₄ films were deposited with an 8 second spray time with a Cu(II)/Mn(III) molar ratio of 0.54 in the suspension.

Sample No.	Spray Time (seconds)	$\text{CuO}/\text{Cu}_{1.4}\text{Mn}_{1.6}\text{O}_4$	Transmitted chromaticity values for as deposited film ill.A, 2°			Change in transmitted chromaticity values after heat treatment at 650°C, 10 min. ill.A, 2°		
			X	Y	ΔY	X	ΔX	ΔY
D1	2/8		before heat treat	47.20	0.4271	0.4086		
			after heat treat	53.03	0.4317	0.4092	5.83	0.0046
D2	3/8		before heat treat	42.97	0.4279	0.4088		
			after heat treat	44.78	0.4245	0.4076	1.81	-0.0034
D3	4/8		before heat treat	40.09	0.4328	0.4099		
			after heat treat	40.83	0.4273	0.4085	0.74	-0.0055
D3	6/8		before heat treat	33.01	0.4333	0.4111		
			after heat treat	33.55	0.4280	0.4096	0.54	-0.0052
D4	8/8		before heat treat	34.03	0.4444	0.4126		
			after heat treat	34.72	0.4408	0.4119	0.69	-0.0036

The two layer system (glass/CuO/Cu_{1.4}Mn_{1.6}O₄) did not give the typical blue color associated with a Cu_{1.4}Mn_{1.6}O₄ spinel-type phase due to the presence of the light brown colored CuO bottom layer. The two layer system was heat treated for 10 minutes at 650°C and compared with a single layer as-deposited and unheated sample having a Cu_{1.4}Mn_{1.6}O₄ spinel-type phase coating. Results of varying the Cu/Mn molar ratio from 0.82 to 1.49 in the top coat with the same CuO bottom layer (the layer close to the glass) and comparing the as-deposited two layer system with the same heat treated two layer systems are shown on Table IV. After heating each of the two layer systems, the transmitted color was again blue due to the diffusion of Cu ions from the concentration gradient deterrent CuO layer in the glass, leaving behind a desired Cu_{1.4}Mn_{1.6}O₄ blue colored spinel-type top layer. The change in transmittance (bleaching), ΔY , before and after heat treatment with a two layer system was reduced from 11% to 0.75% for a Cu/Mn ratio of 0.82 and from 6.4% to 0.26% for a Cu/Mn ratio of 1.00 and from 3.4% to -0.32% (darkened after heat treatment) for a Cu/Mn ratio of 1.49. Additionally, the ΔE (FMCII) (the color change in Mac Adam Units for the above-mentioned three samples) decreased from 18.1 to 3.4, 17.8 to 3.7 and 15.1 to 4.9 respectively as a result of the presence of the CuO layer on the supported surface of the glass.

Table IV

Sample No.	Film Deposited on Glass. Unheated and Heated (htd)	Cu(II) / Mn(III) Suspension Mole Ratio	Suspension of Acetylacetone (Ac Ac'). Spray Time in sec.	Transmitted chromaticity values for as deposited film				Change in transmitted chromaticity values after heat treatment at 650°C, 10 min.				ΔE (FMCII)
				Cu(II) Ac Ac	Cu(II) Ac Ac-Mn(III) Ac Ac	Y	X	Y	ΔY	ΔX	ΔY	
E1	CuMnOx	0.82	0	8	45.77	0.4327	0.4095					
E2	CuMnOx (htd)			56.78	0.4345	0.4091	11.01	0.0018	-0.0004	-0.0004	-0.0004	18.08
E3	CuO/CuMnOx	0.82	8	38.08	0.4505	0.4131						
E4	CuO/CuMnOx (htd)			38.83	0.4472	0.4127	0.75	-0.0034	-0.0004	-0.0004	-0.0004	3.42
E5	CuMnOx	1.00	0	8	40.93	0.4397	0.4112					
E6	CuMnOx (htd)			47.32	0.4267	0.4079	6.39	-0.0130	-0.0033	-0.0033	-0.0033	17.76
E7	CuO/CuMnOx	1.00	8	32.61	0.4524	0.4133						
E8	CuO/CuMnOx (htd)			32.87	0.4482	0.4126	0.26	-0.0042	-0.0007	-0.0007	-0.0007	3.67
E9	CuMnOx	1.5	0	8	37.34	0.4449	0.4123					
E10	CuMnOx (htd)			40.82	0.4310	0.4091	3.48	-0.0139	-0.0033	-0.0033	-0.0033	15.08
E11	CuO/CuMnOx	1.5	8	31.31	0.4524	0.4136						
E12	CuO/Cu MnOx (htd)			30.99	0.4467	0.4125	-0.32	-0.0057	-0.0011	-0.0011	-0.0011	4.89

The addition of other metal containing components, such as transition metal containing acetylacetones, modifies the reflected and transmitted properties of the coating to alter the color and absorption of the coating. For example, 5 MnCuCr oxide films tend to be neutral gray.

While in the above-described examples the copper containing acetylacetones and manganese containing acetylacetones were sprayed onto the heated substrate as a mixture, individual acetylacetone suspensions may be sprayed sequentially onto a heated substrate to achieve the same 10 desired color. For example, a suspension of a copper containing material, such as cupric acetylacetone, can be sprayed onto a heated glass substrate, the substrate cooled and reheated and then sprayed with a manganese containing 15 material, such as manganous or manganic acetylacetone, to produce the desired, for example blue, color of the Cu-Mn chromophore described above utilizing, for example, the coating device shown in Fig. 2. Manganous or manganic acetylacetone may be first sprayed onto the substrate, 20 followed by a separate coating of cupric acetylacetone. Again, regardless of the sequence of deposition, the desired color is achieved. Further, as can be appreciated, the temperature of the substrate during coating is not limited to 25 the invention and any temperature at which pyrolysis coating occurs is acceptable, e.g. 400°C and 900°C. Further as can be appreciated a binary or tertiary metal acetylacetone may also be used to deposit the films e.g. $A_xB_y(C_5H_7O_2)_l$ where A or B are any metal ions e.g. copper or manganese and x, y and l are 30 the number of moles to balance the equation for the desired binary acetylacetone compound.

While the manganous or manganic and cupric acetylacetone systems described above were successful in producing blue chromophores, the resulting blue coatings had relatively poor acid resistance.

35 The following experiment was conducted to find mole ratios of a copper/manganese system to give a desired color

with durability. Substrates were cleaned as previously discussed for the substrates of Example #1. The coating material was a mixture of finely ground manganic, cupric and cobaltic acetylacetones. The ground materials were suspended in an aqueous suspension; the suspensions having the starting compositions are listed on Table V. The results of eight samples are shown in Table V for different Cu(II)/Mn(III) mole ratios in suspension. The compositions of the starting mixture and the resulting films were analyzed by D.C. plasma analysis. The films which were blue-gray color in transmittance were found to have a Cu/Mn molar ratio in the range of about one. The other compositions were amber in appearance. The right column of Table V gives the results of the coating tested in accordance with a conventional ASTM 282-67 test (STANDARD TEST METHOD FOR ACID RESISTANCE OF ENAMEL, CITRIC ACID SPOT TEST). A "yes" indicates acceptable durability.

Table V

Sample No.	Starting Composition % (DCP)			CuII/MnIII Suspension Mole Ratio	Film Cu/Mn Mole Ratio	Transmitted Color	Citric Acid Durability
	Mn	Cu	Co				
C1	34.7	31.7	33.6	0.79	0.95	Blue-gray	No
C2	55.3	11.9	32.8	0.19	0.25	Amber	No
C3	55.2	31.4	13.5	0.49	0.62	Amber	No
C4	26.8	24.1	49.1	0.78	1.09	Blue-gray	Yes
C5	44.6	30.5	24.9	0.59	0.76	Amber	No
C6	22.8	20.9	56.3	0.79	1.25	Blue-gray	Yes
C7	26.8	17.8	55.4	0.57	0.88	Blue-gray	Yes
C8	36.2	9.6	54.2	0.23	0.32	Amber	Yes

As can now be appreciated, adding cobaltic acetylacetone Co(C₅H₇O₂)₃ to a manganese and copper containing acetylacetone system produces a pyrolytic coating of a desired blue-gray color. This Cu/Mn/Co mixture also provides greatly improved acid resistance. The acid resistance increases to a maximum when the cobalt content of the mixture is above about 50 wt%. As discussed, this increase in acid resistance was visually determined in accordance with a conventional ASTM 282-67 test (Standard Test Method for Acid Resistance of Enamels, Citric Acid Spot Test). This increase in acid durability is believed to be caused by a higher stability of the Co/Cu/Mn matrix compared to the stability of the Cu/Mn matrix.

15

IRON OXIDE COMPOSITIONS

Iron oxide coatings pyrolytically formed on glass generally yield a bronze or gold colored film in transmission and enhance the solar performance of the glass by among other ways absorbing part of the solar spectrum in the visible region reducing the heat load through the glass. The iron oxide can be applied to hot glass by spray pyrolysis or by chemical vapor deposition. For pyrolytic coatings, the preferred method is to spray an iron containing material, such as an aqueous suspension of ferric acetylacetone, onto the glass to form the iron oxide coating.

The color of the iron containing chromophore can be changed by adding additional metal ions to form a binary or ternary metal oxide thin film. For example, a binary Cu-Fe oxide coating tends to have a light grayish-amber color in transmission when formed on a clear glass substrate. A ternary oxide compound formed from materials e.g. acetylacetones, of Cu, Cr and Fe produces a dark grayish-amber absorbing film on a clear glass substrate. In addition compounds having acetylacetones of cobalt, manganese, aluminum, cerium, calcium, titanium, yttrium, zinc, zirconium

and tin may be used to vary the color of the deposited film.

A problem with typical iron oxide coatings is that they tend to darken upon further heat treatment, such as tempering or bending. This darkening is believed to be caused by an increase in crystallization and grain size produced at the temperatures required for tempering or bending. While, it may be possible to add a barrier layer between the iron oxide and the glass to help prevent such darkening, this darkening can be diminished by adding a selected second component to the iron oxide system, such as, but not limiting to the invention, Ca, Cu, Al, Ce, Mg, Mn, Ti, Y, Zn, Zr.

Prevention of Darkening

A calcium acetylacetone suspension was combined with an iron acetylacetone suspension of different mole ratios and pyrolytically sprayed onto a heated glass substrate to form an iron calcium oxide thin film. The substrate was cleaned as previously discussed. Two pieces of clear glass, 4 inches (10.2 cm) square were sprayed for the time listed in Table VI with the same molar solution listed in Table VI. One piece was heat treated. The film thicknesses were not measured. Sample F2 had a luminous transmittance LT_A measured as previously discussed of 66.94%. After heat treatment, LT_A was 66.85%, giving a change in LT_A of less than 1%. Sample F1 which is an FeO_x film deposited onto the glass piece and subsequently heat treated ($650^{\circ}C$, 10 minutes) resulting in the coating darkening with a change in LT_A of -7.65% (63.32% transmission before heating and 55.67% transmission after heating). Similar results are shown for Fe-Mg oxide and Fe-Zr oxide (Samples F4-F6) where the binary metal oxide changes much less in luminous transmittance than does the single metal oxide FeO_x (F1).

Table VI

Sample	Fe(III)/X Suspension Mole Ratio	Spray Time, seconds	* ill. A, 2°			** ill. A, 2°		
			Y	X	Y	ΔY	Δx	ΔY
F1	Fe(III) only	12	63.32	0.4819	0.4186			
F1(htd)	Fe(III) only		55.67	0.5009	0.4136	-7.65	0.0190	-0.0050
Sample	Fe(III)/Ca(II) Suspension Mole Ratio	Spray Time, seconds						
F2	2	15	66.94	0.4782	0.4185			
F2(htd)	2		66.85	0.4791	0.4182	-0.09	0.0009	-0.0003
F3	4	10	76.15	0.4688	0.4176			
F3(htd)	4		75.02	0.4714	0.4168	-1.13	0.0026	-0.0008
Sample	Fe(III)/Mg(II) Suspension Mole Ratio	Spray Time, seconds						
F4	1	20	76.66	0.4625	0.4165			
F4(htd)	1		75.54	0.4647	0.4173	-1.12	0.0022	0.0008
F5	2	20	68.22	0.4723	0.4183			
F5(htd)	2		68.05	0.4734	0.4187	-0.17	0.0011	0.0004
Sample	Fe(III)/Zr(IV) Suspension Mole Ratio	Spray Time, seconds						
F6	2	16	75.31	0.4691	0.4176			
F6(htd)	2		75.83	0.4687	0.4175	0.52	-0.0004	0.0000

*Transmitted chromaticity values for as deposited film.

**Change in transmitted chromaticity values after heat treatment at 650°C, 10 minutes.

ADDITIONAL COLORED OXIDE FILMS IN TRANSMISSION

Mauve/lavender colored films in transmission can be produced by Mn_2O_3 oxide films formed on a clear glass substrate. An Mn_3O_4 oxide film formed on a clear glass or 5 quartz substrate produces a light amber color in transmission. This ambercolored film can be transformed into a mauve/lavender colored film by heating, such as by heating the coated substrate to 650°C for 8-30 minutes. For improved aesthetics, a silicon containing barrier layer can be used to 10 form a more uniform color. For example, a silicon oxide layer may first be deposited onto the clear float glass substrate before spraying the manganese containing acetylacetone suspension onto the clear float glass. The silicon containing layer can be as thin as 20 nanometers. This mauve/lavender 15 colored coating in transmittance has been found to contain mostly Mn_2O_3 by X-ray diffraction. The mauve/lavender coating was tested for citric acid resistant per the above mentioned ASTM 282-67 test and found to be citric acid durable.

Co-Mn Oxide systems Co(II), Co(III) Mn(II), 20 Mn(III), combinations in suspension)may be used in the practice of the invention. Two systems used were a Co(II)/Mn(II) system and a Co(III)/Mn(II) system. These systems have been found to produce coatings having transmitted colors ranging from brown to gray brown to light green to 25 light yellow-green when viewed in transmittance by the unaided eye under fluorescent lighting conditions as the Co to Mn molar ratio in suspension is varied from 9.0 - 0.1 (See Table VII).

In making some of the suspensions discussed above 30 surfactants were used. As can be appreciated by those skilled in the art, the use of surfactants have minimal if any effect on the results obtained.

Table VII

Reflectance and Transmittance CIE Chromaticity Coordinates for Co/Mn Oxide Films on Clear Glass

Sample	Co(II)/Mn(II)	Co/Mn Molar Ratio in Suspension	ill1.A, 2°	ill1.A, 2°			ill1.A, 2°			ill1.A, 2°		
				**			***			****		
				Y	X	Y	X	Y	X	Y	X	Y
X1	9.00	48.73	13.64	0.4231	0.4058	8.56	0.4394	0.4184	69.62	0.4586	0.4135	
X2	2.33	5.78	17.39	0.4280	0.4070	9.69	0.4357	0.4143	60.37	0.4592	0.4122	
X3	1.00	2.02	14.20	0.4284	0.4024	8.47	0.4335	0.4066	67.91	0.4533	0.4123	
X4	0.43	0.81	17.35	0.4148	0.3969	13.46	0.4077	0.4053	68.98	0.4554	0.4170	
X5	0.11	0.24	15.92	0.4136	0.3964	13.08	0.4152	0.4047	74.26	0.4562	0.4157	
Sample	Co(III)/Mn(II)	Co/Mn Molar Ratio in Suspension	ill1.A, 2°	ill1.A, 2°			ill1.A, 2°			ill1.A, 2°		
				Y	X	Y	X	Y	X	Y	X	Y
X6	9.00	19.31	19.01	0.4242	0.4092	10.77	0.4329	0.4200	57.87	0.4641	0.4130	
X7	2.33	3.96	15.95	0.4282	0.4053	9.04	0.4360	0.4115	63.18	0.4568	0.4122	
X8	1.00	1.64	21.95	0.4269	0.4020	14.24	0.4202	0.4054	55.25	0.4579	0.4144	
X9	0.43	0.66	16.75	0.4138	0.3965	13.03	0.4086	0.4052	71.39	0.4547	0.4168	
X10	0.11	0.16	19.27	0.4132	0.3977	16.32	0.4134	0.4048	71.17	0.4592	0.4162	

*See Table I

**See Table I

***See Table I

It will be readily appreciated by those skilled in the art that modifications may be made to the invention without departing from the concepts disclosed in the foregoing description. Such modifications are to be considered as included within the scope of the invention. Accordingly, the particular embodiments described in detail hereinabove are illustrative only and are not limiting as to the scope of the invention, which is to be given the full breadth of the appended claims and any and all equivalents thereof.